

Date: Thursday, 6/29/2006 8:28:12 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT BRACKET
Job Number : 27765	
Estimate Number : 10260	
P.O. Number : N/A	Part Number : D23623
This Issue : 6/29/2006 S.O. No. : N/A	Drawing Number : D2362 REV E1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : E1
Previous Run : 27309	Material : N/A
Written By : <i>See Comment Below</i>	Due Date : 7/30/2006
Checked & Approved By : <i>060629</i>	Qty : 10 Um : Each
Comment : Est: G 0003.18 Added inspection level 8 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2265	Step Support Casting
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Step Support

Pick:

Qty	Part Number	Description	Batch
1	D2265	Step Support	<i>B25401</i>

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: Machine per folio D2362-3

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: Inspect Level 2

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Debutr

6.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Gloss White (Ref 4.3.5.1) as per Dart QSI 005 4.3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DP Date: 06/08/0

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/29/2006 8:28:12 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT BRACKET

Job Number: 27765

Part Number: D23623

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

8.0

D23971

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-1

Rubber

B25469 (1mx) B 27768 (9 mx)

9.0

D23973

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-3

Rubber

B25470 (1mx) B 27769 (9mx) MF 06/08/03

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond rubber D2397-1 followed by D2397-3 using contact cement

as per Dwg D2362

Batch M16194

MF 06/08/03 (10)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-08-04 (10)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST173

06/08/08 (10)

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/08/09

Job Completion



W 06/08/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	27765
Description: Step Support Bracket		Part Number:	D2362-3
Inspection Dwg: D2362 Rev: E1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.005 -0.000	.259	✓			
3.074	+/-0.010	3.072	✓			
0.34	+/-0.030	.345	✓			
0.77	+/-0.030	.760	✓			
1.500	+/-0.010	1.500	✓			
1.000	+/-0.010	1.010	✓			
0.80	+/-0.030	.770	✓			
1.200	+/-0.010	1.210				
1.28	+/-0.030	1.265	✓			
1.000	+/-0.010	.995	✓			
0.75	+/-0.030	.756	✓			
1.88	+/-0.030	1.875	✓			

Measured by:	J.L	Audited by:	me	Prototype Approval:	N/A
Date:	06/07/27	Date:	06/07/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF	TF

DART



RELEASED
98.12.14 KE

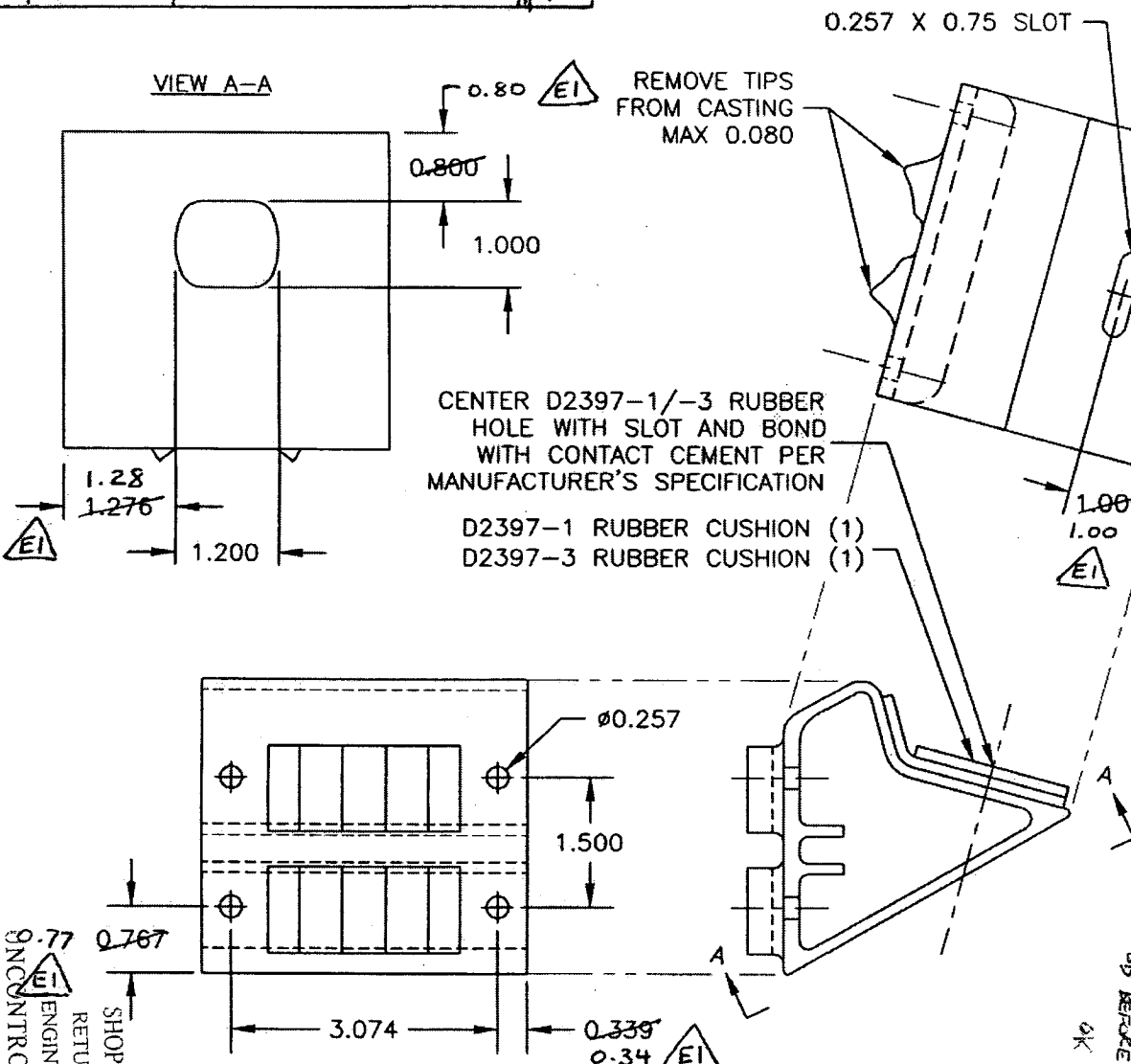
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
BW	APPROVED	DRAWING NO.	SHEET 1 OF 3
CHECKED	DATE	D2362	SCALE
KE	98.12.04	STEP SUPPORT BRACKET	1:2
A	95.02.15	NEW ISSUE	
B	95.03.22	CHANGED RUBBER TO D2397	
C	96.01.22	ADD D2362-5	
D	97.05.21	ADD D2362-7	
E	98.12.04	REDRAWN, ADD 2397-5	

UNDER REVIEW

01.03.15 CP

DESIGN OK, BUT CHECK WITH
BIG BEFORE MANUFACTURE
OK 01.04.04

D2362-3



NOTES:

MAKE FROM D2265
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING
RUBBER IN PLACE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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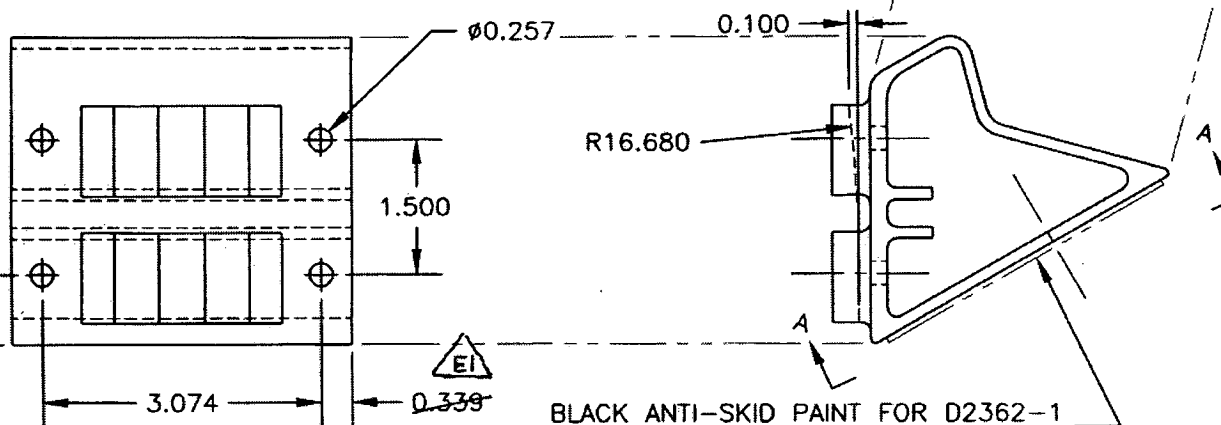
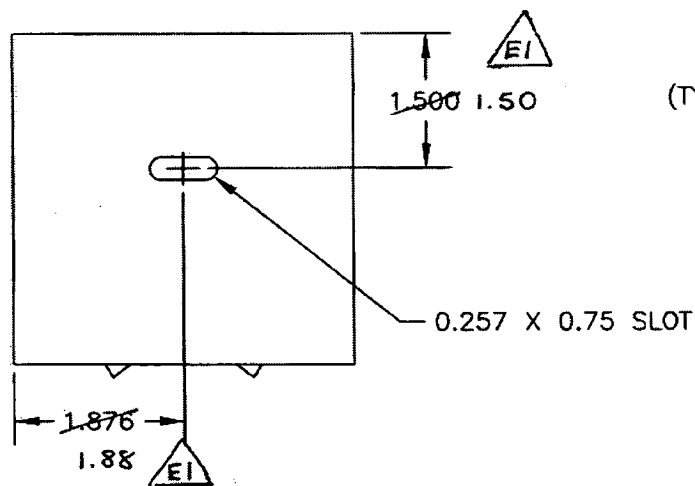
WITHOUT NOTICE
WORK ORDER
NO. 27765

77
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SHOP COPY
SUBJECT TO AMENDMENT



DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED CP	DRAWING NO. D2362
DATE 98.12.04	TITLE STEP SUPPORT BRACKET	REV. E SHEET 2 OF 3

VIEW A-A



BLACK ANTI-SKID PAINT FOR D2362-1
INSTALL D2397-5 (1) FOR D2362-5

D2362-1 & D2362-5

RELEASED
98.12.14
UNDER REVIEW

DESIGNED, BUT NOT CHECKED BY
D23 BEFIRE MANUFACTURE
OK 98.12.05

NOTE:
MAKE FROM D2265
D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT
AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
NO. 27765

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D2362-041 (SHOWN)

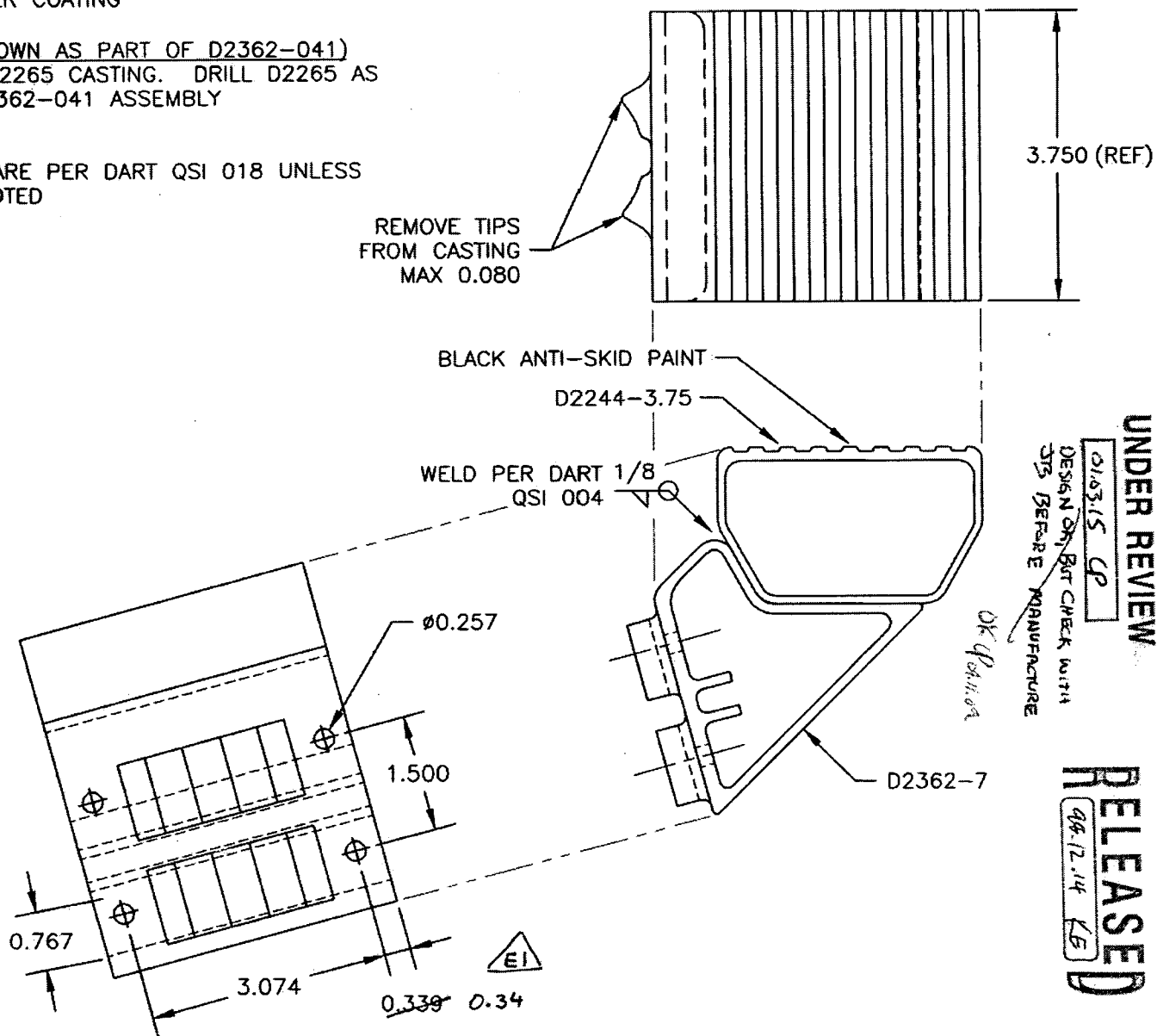
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PIAINT PER QSI 005 4.4 AFTER
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)

MAKE FROM D2265 CASTING. DRILL D2265 AS
SHOWN IN D2362-041 ASSEMBLY

NOTES:

TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED



UNDER REVIEW

01.03.15 CP
DESIGN ON BUT CHECK WITH
JIS BEFORE MANUFACTURE



DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. E
BW	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED KE	DRAWING NO. D2362	SHEET 3 OF 3
DATE 98.12.04	TITLE STEP SUPPORT BRACKET	SCALE 1:2	

